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Lotus I

Patent Claims

1. Process for manufacturing blown film tubes (3) that are equipped with at least one self -cleaning surface that includes the following characteristics of the process:
 - Formation of a plastic melt in an extruder (2)
 - Compression of the plastic melt in a blowing head that has a ring-shaped output gap.
 - Extrusion of a film tube (3) from this ring-shaped gap
 - Expansion of the radius (R1) of the film tube (3) by creating a corresponding pressure inside the film tube (3) by the blow factor (FR)
 - Squeezing the film tube (3) with nip rollers (4)
 - Stretching the film tube (3) in its axial direction (z) by the length stretch factor (FZ)**characterized by the fact that,**
 - at least one surface of the film tube (3) is provided with elevations in that the material required for the formation of the elevations is added either before the extrusion of the plastic melt from the ring-shaped gap or is spread on at least one surface of the film tube (3) after the extrusion.

2. Process in accordance with claim 1
characterized by the fact that
the matter volumes required for the formation of elevations are a component of another melt.
3. Process in accordance with claim 1
characterized by the fact that
particulates (10) are used for the formation of elevations.
4. Process in accordance with claim 3
characterized by the fact that
the particulates (10) are nanoparticles.
5. Process in accordance with one of the aforesaid claims
characterized by the fact that
the ratio between the blow factor (FR) and the length stretch factor (FZ) is larger than $1/4$.
6. Process in accordance with claim 5
characterized by the fact that
the ratio between the blow factor (FR) and the length stretch factor (FZ) is larger than $1/3$.
7. Process in accordance with claim 6
characterized by the fact that
the ratio between the blow factor (FR) and the length stretch factor (FZ) is larger than $1/2$.
8. Process in accordance with claim 7
characterized by the fact that

the ratio between the blow factor (FR) and the length stretch factor (FZ) is larger than $2/3$.

9. Process in accordance with claim 8

characterized by the fact that

the ratio between the blow factor (FR) and the length stretch factor (FZ) is larger than $10/11$.

10. Process in accordance with claim 9

characterized by the fact that

the ratio between the blow factor (FR) and the length stretch factor (FZ) is larger than $1/1$.